

Date: Wednesday, 26/11/2008 8:27:42 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FUEL PURGE CANISTER
Job Number : 43642	
Estimate Number : 10440	
P.O. Number :	Part Number : D3262041
This Issue : 26/11/2008 S.O. No. :	Drawing Number : D3262 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 20/11/2008 Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 41823	Material :
Written By :	Due Date : 21/12/2008 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32621	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Tube *B 37369 A*

BE 08/11/26

2.0	D32623	Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Cap *B 41823*

BE 08/11/26

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 Weld canister assembly as per Dwg D3262 using DT8739 to align fillings
 Pick: Qty Part Number Description Batch
 A/R Aluminum Rod *M/07813 BE 08/11/26*

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: WELD INSPECTION
 Pressure test as per Dwg D3262

BE 08/11/27 (4)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

No leaks - P
Soslu 27 (X40)

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Drawing Name: FUEL PURGE CANISTER

Job Number: 43642

Part Number: D3262041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(4X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF 08/11/27

7.0

POWDER COATING

POWDER COATING



(4X)

Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10-45
320 OF
11-15

MF 08/11/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-22 (X4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(4X)

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location:

164 8/11/27

54

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/28 fg

Job Completion

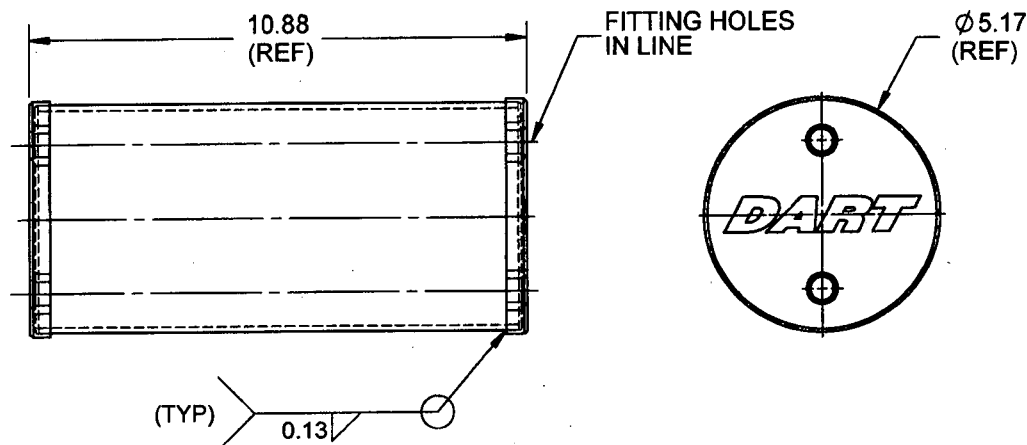


MF 08-11-27

DART

DESIGN <i>PH</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø5.165 WAS Ø5.190	

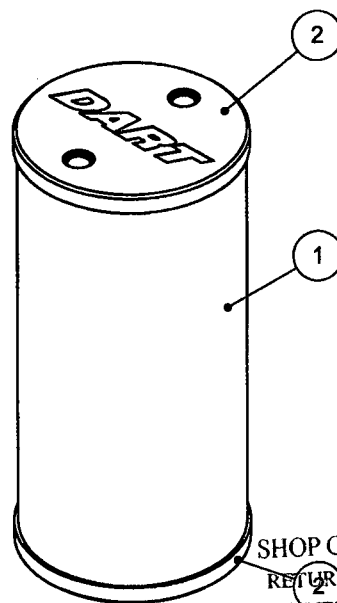
RELEASED

06.09.19 *PH***D3262-041 CANISTER ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



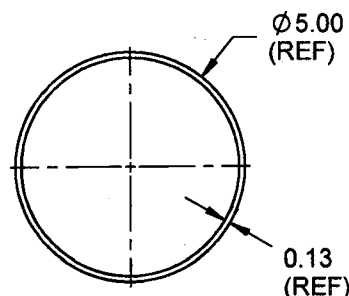
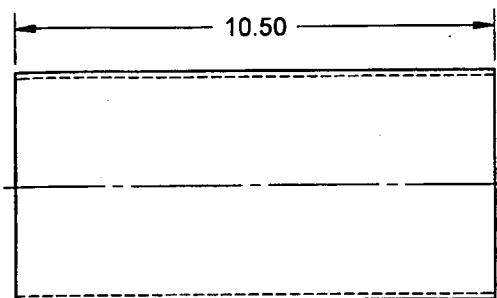
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WITHOUT NOTICE
WORK ORDER
NO. *43672*

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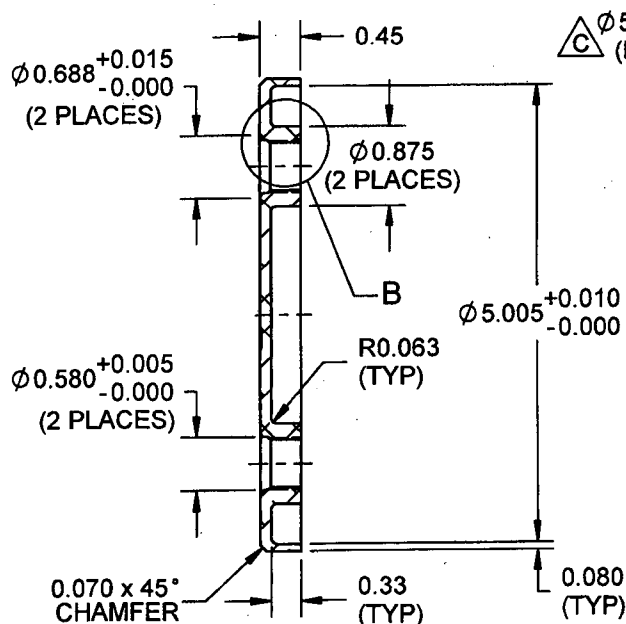
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	SHEET 2 OF 2
DATE 06.08.31	TITLE FUEL PURGE CANISTER	SCALE 1:4	



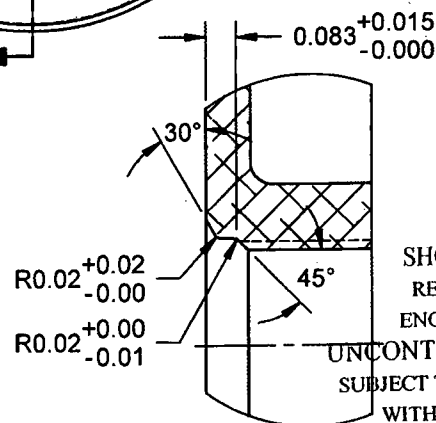
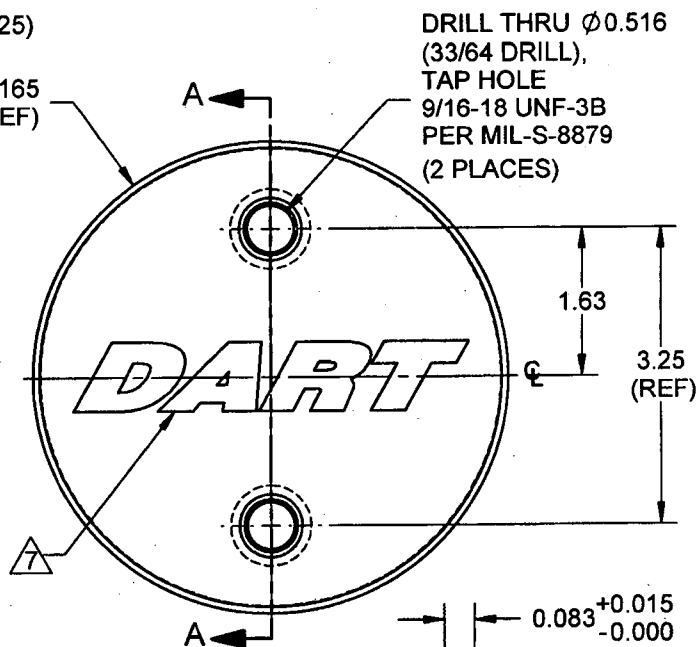
RELEASED
06.09.11

D3262-1 TUBE

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)



SECTION A-A
SCALE 1:2



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WITHOUT NOTICE
WORK ORDER
SCALE 2: NO. 43642

D3262-3 CAP

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

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